

Date: Wednesday, 3/26/2008 9:53:56 AM
 User: Kip Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RADIUS BLOCK
Job Number : 38173	
Estimate Number : 10822	
P.O. Number :	Part Number : D2274
This issue : 3/26/2008 S.O. No. :	Drawing Number : D2274 REV F
Prsht Rev. : NC	Project Number : N/A
First Issue : / /	Drawing Revision : F
Previous Run : 37630	Material :
Written By :	Due Date : 4/20/2008
Checked & Approved By : <u>JD 08.3.27</u>	Qty: <u>525</u> Um: Each
Comment : Est. H 00.05.18 Added inspection level 8 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0750X00125	6061-T6 Bar .75" x .125"
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Comment: Qty.: 0.0962 f(s)/Unit Total : 48.0900 f(s)
 6061-T6 Bar .75" x .125"

Material: 6061-T6 (QQ-A-250/11) or 5052-H34 (QQ-A-250/8) 1/8" X 3/4" BarBatch M 103503 MK 08/03/30 (525)

2.0	SHEAR	SHEAR
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Comment: SHEAR
 Shear blanks 9.00" long +/- 0.030"
 Note: 1 blank makes 9 pieces

MK 08/03/30 (525)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per folio D2274

DIP / M.A 08/03/31 (525)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DIP / M.A 08/03/31 (525)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

MK 08/03/31 (525)

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Tumble
 Deburr any rough edges after tumbling

EB 08/04/03 525

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

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Drawing Name: RADIUS BLOCK

Job Number: 38173

Part Number: D2274

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JS

08-04-04

525

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 08-04-04 525

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 24

8/4/4

50 525

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/08

JS

Job Completion



u 08-04-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

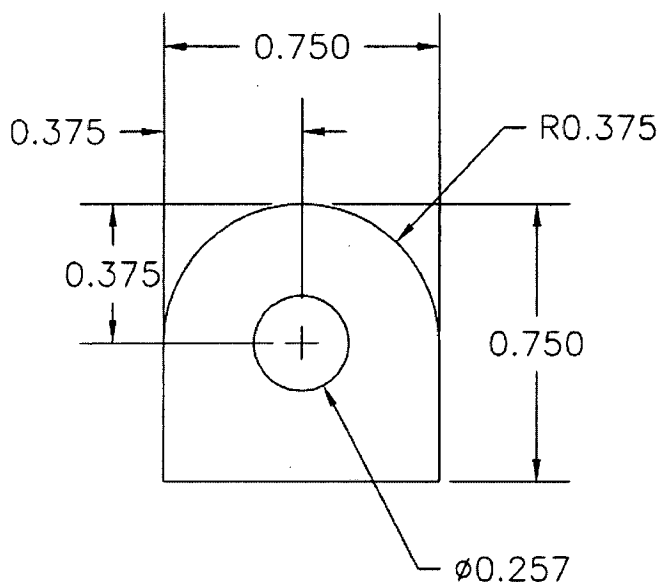
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11		TITLE RADIUS BLOCK	SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

RELEASED
98/08/18 KE



00.05.16
00.05.16

0.063 x 45° CHAMFER
R0.0 - 0.13

MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
OR 6061-T6 (QQ-A-250/11) 0.125 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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